

Date: Wednesday, 3/8/2006 12:01:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOLDING STEP WELDMENT LH
Job Number	: 26156		
Estimate Number	: 10463		
P.O. Number	: N/A	Part Number	: D3388041
This Issue	: 3/8/2006	Drawing Number	: D3388 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 25926	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 4/10/2006
Checked & Approved By	: <u>06.03.08 W</u>	Qty:	4 Um: Each
Comment	: Est. B 05.06.10 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 D2622-120C extrusion 8
 Batch: 324563

1-E. 06.04.29 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388
 2-Deburr and bevel ends for welding

1-E. 06.04.29 4
1-E. 06.05.1 4

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 206 Step Endplate
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>324402</u>

1-E. 06.05.14 4

4.0	D33871	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Arm
 Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<u>326651=4</u> <u>326670=4</u> <u>1-E. 06.05.14</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

L.E. 06.05.01

FB 06.05.04

4

4

(PTD)

2

(4)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. 06-05-09 (2)

H.M. 06/05/09

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/05

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FL 06.06.06

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

SAN 06:06:08

(4)

10.0 D2808 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Pick:

Qty:

Part Number

Description

Batch

D2808

Spacer

H26648

SAN 06:06:08

4

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SAN 06:06:08

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-05-08	5.1	Inspect QC 519	[Signature]	06-05-08	4	[Signature]	[Signature]	
	6.1	Inspect Alocine QC 3	[Signature]	06-05-10	4	06-05-08	06-05-08	
	6.2	Weld 2nd end cap A1 per dwg and grind flush. QSI 004 / FF 06-05-11	[Signature]	06-05-10	4	[Signature]	[Signature]	
	6.3	Inspect QC 519	[Signature]	06-05-12	4			
	6.4	Alocine end cap A5 per QSI 005.						
		Add steps to IPP for permanent change [Signature]						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/06/08

(4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

G-A

SAP

06/06/08

(4)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/08

(4)

Job Completion



U 06-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

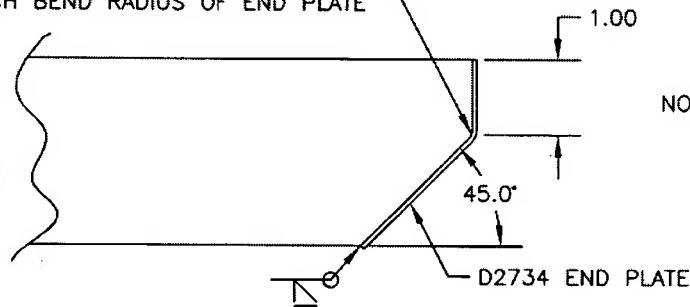


RELEASED

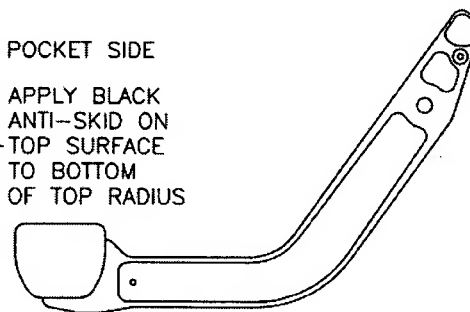
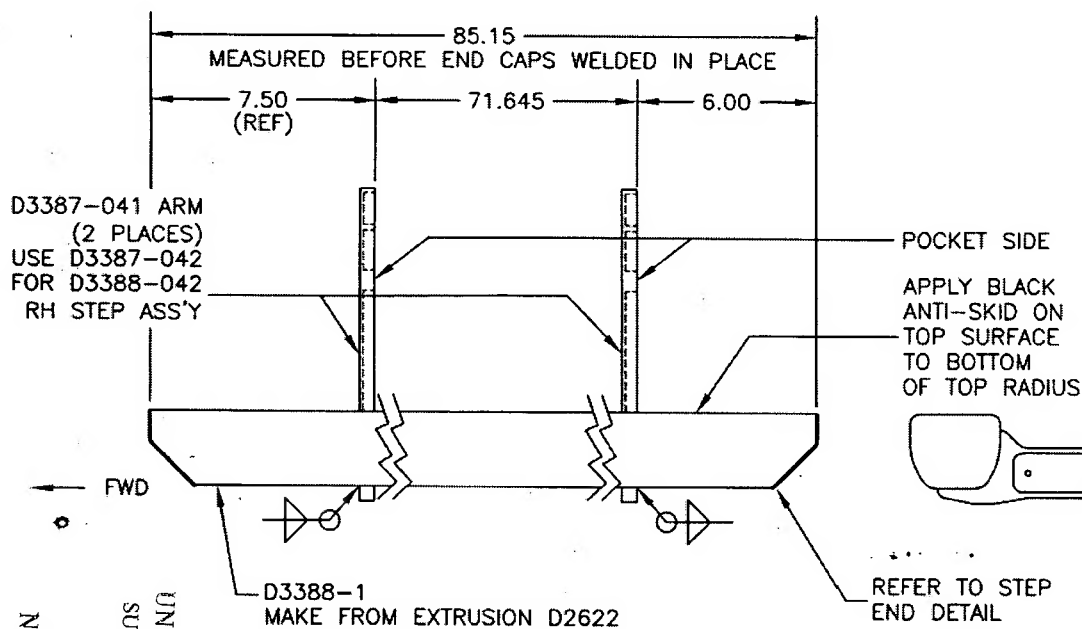
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)

OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP	CP	D3388	
DATE	TITLE	SHEET 1 OF 1	
05.01.20	STEP WELDMENT	SCALE	
A	05.01.20	NTS	

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26156

